

Work Order ID 83828

Thursday, April 26, 2012 1:07:58 PM

83828

Page 1

Item ID: D4462-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Baffle
 Start Date: 4/26/2012 Start Qty: 4.00 ***4*** Cust Item ID: \
 Required Date: 5/3/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 2-04-26 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(4)			
D4462	B								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut as per dwg
 6061. OSC Prog rev: B
 Dwg rev: B

110 0.00
110
 QC Memo 0.00
 Quality Control

120 0.00
120
 QC Memo 0.00
 Quality Control

QC2- Inspect parts off machine FAI/FAIB

QC8- Inspect parts - second check

Sczkuliz

B 12-4-07

B 12-4-07

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Quality Control

4 0 12:04:30

4 0 12:04:30

12/5/17

UMF
12-05-01

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 26, 2012 1:07:58 PM

Page 1

Work Order ID: 83828

Parent Item: D4462-3

Parent Item Name: Baffle

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 6061-T6 .050 Sheet		Purchased	No			100	sf	245.6640	2.564	10.795789			

Location

Loc Qty

Loc Code

021

144

1211920

144

MAT021

101.664

113216

10

114799

76.664

114993

15

113216

1312-4-07
(4)

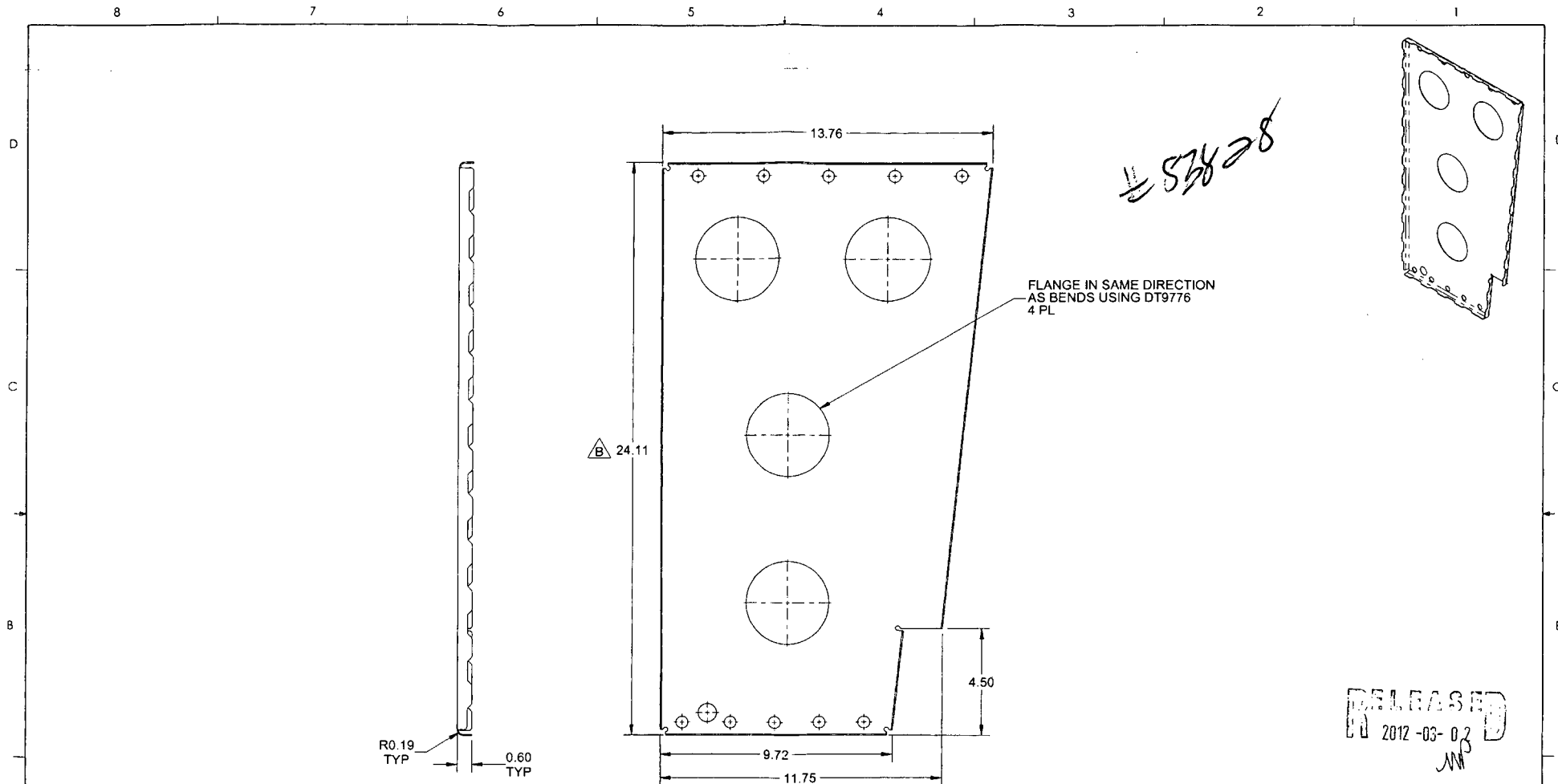
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4462-3 BAFFLE

NOTES:

- 1) MATERIAL: MADE FROM D4462-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs
- 8) BEND ANGLE: 90° +/- 5°

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4462	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BAFFLE	NTS
DATE	11.12.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

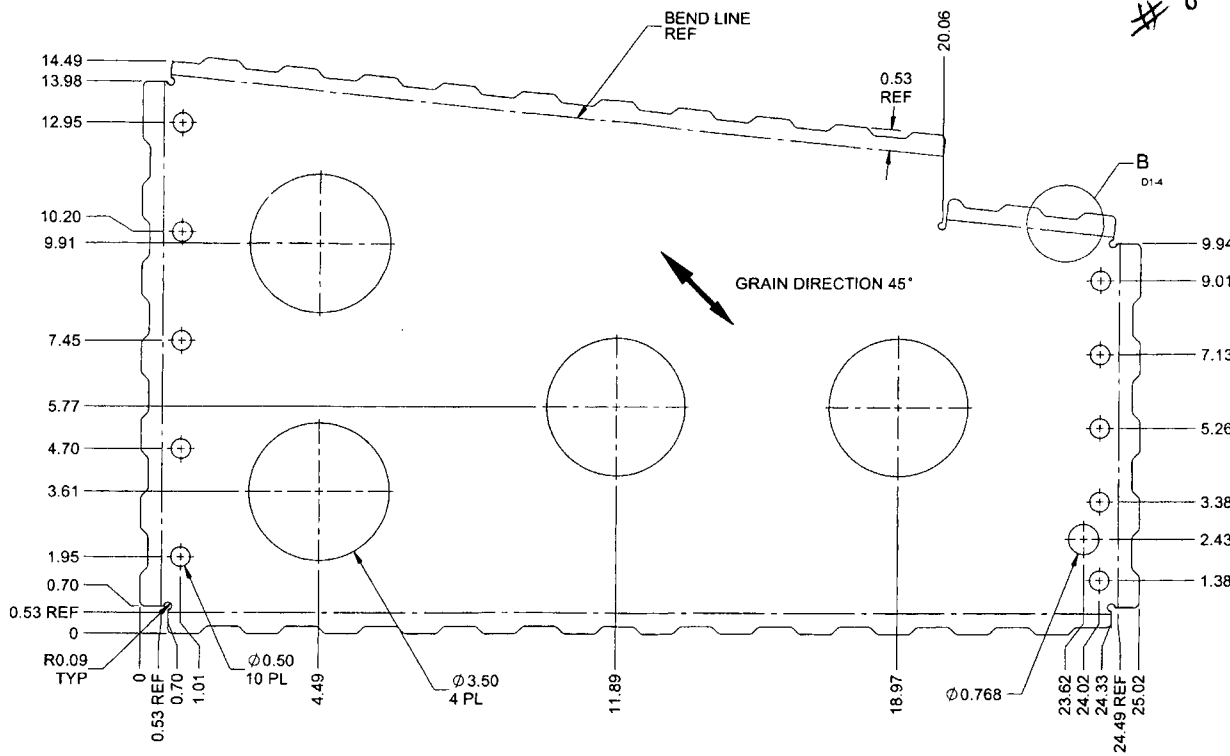
D

C

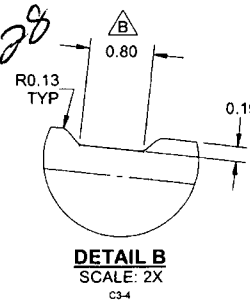
B

A

0.050
REF



83828



D4462-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4462	SHEET 4 OF 4
APPROVED	4/1	TITLE	SCALE
DE APPR.	4/1	BAFFLE	NTS
DATE	11.12.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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RELEASED
2012-03-03
WMP

8 7 6 5 4 3 2 1

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DART AEROSPACE LTD		Work Order: 83828
Description: BAFFLE		Part Number: D4462-3
Inspection Dwg: D4462-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .50	+ .006 - .001	.499	2		V B52	
Ø .768	+ .010 - .001	.768	2		V	
Ø 3.50	+ .012 - .001	3.499	2		V	
.80	± .030	.801	2		V	
.19	± .030	.185	2		V	
.70	± .030	.702	2		V	
1.01	± .030	1.011	2		V	
4.49	± .030	4.49	2		V	
11.89	± .030	11.89	2		T BCU	
18.79	± .030	18.79	X		T	
23.62	± .030	23.62	X		T	
24.02	± .030	24.00	2		T	
24.33	± .030	24.33	2		T	
25.02	± .030	25.02	2		V	
.70	± .030	.703	2		V	
1.95	± .030	1.954	2		V	
3.61	± .030	3.614	2		V	
4.76	± .030	4.764	2		V	
5.77	± .030	5.773	2		V	
7.45	± .030	7.452	2		V	
9.91	± .030	9.91	2		T	
10.20	± .030	10.20	2		T	

Measured by: B	Audited by: J	Prototype Approval:
Date: 12-4-07	Date: 12/4/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

